Work Order ID 97620 Page 1 February-21-13 1:04:16 PM Item ID: D4114-2 Accept *N900040100* Setup Start **Revision ID:** Stop Door Doubler, RH Item Name: *4* **Start Date:** 2/20/13 Start Qty: 4.00 **Cust Item ID: Reg'd Qty:** 4.00 Required Date: 2/28/13 **Customer:** Reference: Run Process Plan: MCJ Date: 13-02-25 Tooling: Approvals: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Number Stamp Work Center ID Description Code Qty Qty **Run Hours Draw Nbr Revision Nbr** D4114 Α 100 0.00 *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg 304.063 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 JM13.3-17 *110*

0.00

Memo

QC

Quality Control

DQA: _____Date: ______
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Y	es / No				WORK ORDER NON-	CON	IFORM	MANCE / UP				
										QA Closed:	Date	:
Work Orde	r:				DISPOSITION	_			AGAINST DE	PARTMENT	_	
Part N	o				Rework Scrap Use-as-is		Machining Small Fa		Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	0				Work Order Update]		Large Fab	Composite	,	Supplier	
Root				Descri	ption of work order update	ŀr	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
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quip/Tooling												
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Supplier	_											
Fraining	\dashv											
Jnapproved		ļ	<u> </u>			EVIII.	T CATE	GORY		<u> </u>		
Landir	ng Gear				General	TAUL	CAIL	JON				
	Bending			Г	Bend		Grain			Ovalized	Γ	Pressure/Forced
ţ	Centre No	ot Concei	ntric to	o/s	BOM/Route	\vdash	Hardwa	are		Over/Under	tolerance	Temperature/Cure
Ì	Cracks			· -	Broken/Damaged			ion Incomplete		Part Incorre		Weld
ţ	Crushed/	Crimped.			Burrs			tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ì	Cuffs	•			Contamination		Mainte	•		Part Moved		
• †	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
<u> </u>	Inspectio	n Strip in	Tube		Cut Too Short	П	Misread	d		Power Loss/	Surge	Other
Ţ	Ripples in	Bend			Drill Holes	Offset						
Ī	Torque W	/aves in E	Extrusio	n \lceil	Drawing	Out of Calibration						
	Torque Waves in Extrusion Drawin Turning Sequence Finish				Finish		Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

			DQA:	Date:	
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed.	Date.	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	,
i	No					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	No					Work Order Update	·	Large Fab Composit				Supplier	
Root					Descri	ption of work order update	Ini	itial	Act	ion	Sign &		
Cause	D	Date Step Qty or Non-conformance			or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data								,]
Equip/Tooling													
Operator		İ											
Material													
Setup]						•					
Other													
Process]											
Supplier													
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Unapproved												<u> </u>	
						F.A.	AULT	CATE	GORY				
Landi	ng Gear					General					_		_
	Ben	ding			L	Bend		irain			Ovalized	<u></u>	Pressure/Forced
	Cen	tre Not	Concen	tric to	o/s	BOM/Route	Ш	Iardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	:ks				Broken/Damaged	∐'r	nspecti	on Incomplete		Part Incorred	ct	Weld
	Crus	hed/Cri	imped.			Burrs	L Ir	nstruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuff	S				Contamination	١	∕lainte	nance		Part Moved		
	Hea	t Treat				Countersink	<u></u>	∕iislabe	led		Positioned V	Vrong	_
	Insp	ection S	Strip in	Tube		Cut Too Short	\square	⁄lisreac	l		Power Loss/	Surge	Other
	Ripp	les in B	end			Drill Holes		Offset					
	Torque Waves in Extrusion			Drawing		ot of 0	Calibration						
	Turning Sequence Finis			Finish		Out of S	Sequence						
	Wave/Twist in Tube			e		Folio		Outside Dimensions					

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Work Order ID 97620 *97620* February-21-13 1:04:16 PM Item ID: D4114-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Door Doubler, RH **Start Date:** 2/20/13 Start Qty: 4.00 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 2/28/13 **Customer:** Reference: Run Date: **Tooling: Approvals:** Process Plan: Date: Stop Date: _____ SPC (Y/N): Date: Accept Reject Reject Set Up/ Tool ID Tool # Plan Sequence ID/ Operation **Work Center ID** Description Code Qty Qty Number Stamp **Run Hours** Identify as per dwg & Stock Location 150 *150* 0.00 Packaging Memo

160

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

QC

Packaging

Memo

0.00

Page 3

Insp.

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Closed:	Date	

									QA Ciosea.	Date.	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		noforming	Finishing		e/Packaging	Other
NCR N	10.				Work Order Update		Large Fab	Composite		Supplier	1 1
						·					-
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Step Qty or Non-conformance			Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				,							
Operator											
Material						ļ					
Setup											
Other											
Process											
Supplier											
Training											
Unapproved			<u> </u>			<u> </u>					
	<u> </u>					AULT CATE	GORY				
Landi	ng Gear			_	General				!	_	٦ - ا
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardwa			Over/Under	 	Temperature/Cure
	Cracks			ļ	Broken/Damaged	\blacksquare	ion Incomplete	ļ	Part Incorre		Weld
	Crushed/	Crimped.		<u> </u>	Burrs		tions Incomplete/L	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	├ ─	enance		Part Moved		
	Heat Trea			<u> </u>	Countersink	Mislabe			Positioned V		7
	Inspectio	•	Tube	<u> </u>	Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in			<u> </u>	Drill Holes	Offset					
	Torque Waves in Extrusion		Drawing	—	Calibration		· · · · · · · · · · · · · · · · · · ·				
	Turning S	•		<u> </u> _	Finish		Sequence				
	Wave/Twist in Tube				IFolio	I lOutside	e Dimensions				

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Picklist Print

February-21-13 1:04:16 PM

Work Order ID:

97620

Parent Item:

D4114-2

Parent Item Name:

Door Doubler, RH

Start Date: 2/20/13

Required Date: 2/28/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063	· · · · · · · · · · · · · · · · · · ·	Purchased	No			100	sf	589.6560	0.25	1 .052 6316	•		JMB-3-
				Location		Loc Qty	Lo	oc Code					
•				MAT020		589.656							
				1222	45	5.156							
				1231	36	140.8							

124428 124572 123.7

320

NCR:	ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part I	Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			ļ										
Operator													
Material							ļ						
Setup												-	
Other													
Process													
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ing (ear				General		_			•		 -
	Bending				Bend		Grain		·	Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorrect		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Un	nclear	Part Lost/M	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	97620
Description: Door Doubler, RH	Part Number:	D4114-2
Inspection Dwg: D4114 Rev: A		Page 1 of 1

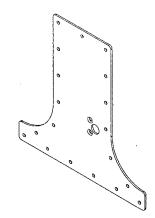
FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			<u> </u>	
Ø0.128	+0.005/-0.001	0.130			V	Janos
Ø0.375	+0.006/-0.001	0.377"			V	
0.25	+/-0.030	0.25%	-		V	
2.250	+/-0.010	2.251"	<u> </u>		V	
1.125	+/-0.010	1.126	ب ا		V	
2.75	+/-0.030	2-751"	•		V	
0.254	+/-0.010	0.257"	_		V	
0.508	+/-0.010	0.509"	~		V	
6.00	+/-0.030	6 004°	_		V	
0.75	+/-0.030	0.75"	_		V	
0.25	+/-0.030	0.361	_		V	
5.50	+/-0.030	5.504"			ン	
. 1.10	+/-0.030	1.103			7	
6.00	+/-0.030	6.001	~		V	
0.64	+/-0.030	0.647"	<u> </u>		V	
1.38	+/-0.030	1,394"	ــــــــــــــــــــــــــــــــــــــ		- V	
2.20	+/-0.030	2.204"			V	
0.75	+/-0.030	D.750"	V		Ů	,
3.30	+/-0.030	3.300	_		V	
1.10	+/-0.030	1.100"	j		V	
0.063	+/-0.010	0.060"			ν	
					-	
				·		· · · · · · · · · · · · · · · · · · ·

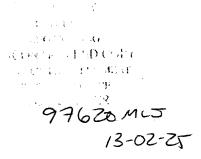
Measured by: Jm	Audited by:	DAS	Preliminary Approval:	
Date: 13.3.17	Date:	9.63 B/03/18	Date:	

Rev	Date	Change	Revised by Approved
Α	11.01.18	New Issue	KJ SET MA

D4114-1 DOOR DOUBLER, LH



D4114-21DOORIDOUBLER, RH



Α	NEW IS	SUE .		JPH	10.07.20		
REV.			DESCRIPTION	BY	DATE		
DESIG	N	JPH	DART AEROSPACE LTD				
DRAW	N	JPH	HAWKESBURY,				
CHEC	(ED	B	DRAWING NO.		REV. A		
MFG. A	PPR.	1/1	D4114		SHEET 1 OF 2		
APPRO	OVED	Tinh	TITLE		SCALE		
DE AP	PR.	-#	DOOR DOUBLER				
DATE	10.0	7.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMANDATE TO JUNY OTHER PERSON WITHOUT WRITELY PRESSED FOR WORLD AND ANY PURPOSE AND LOT AND ANY OFFICE AND ANY TRANSPORT OF THE PERSON WITHOUT WRITELY PRESSED FOR WORLD AND ANY TRANSPORT ID				

2.75 ----- 2.75 **-**D 2.250 2.250 1.125 PITCH 1.125 PITCH 0.25 0.25 0.25 -CSK 0.225 X 100° - 0.254 CSK 0.225 X 100° 0.25 TYP 2 PL TYP 2 PL 3 30 1.10 PITCH 1.10 PITCH R1.50 Ø0.375 R1.50 Ø0.375 0.254 2 PL 6.00 0.254 2 PL + 0.508 0.508 С 2.20 2.20 1.38 1.38 0.64 0.75 0.75 0.64 0.25 R0.11 R0.11 0.25 5.50 TYP 5.50 TYP TYP TYP 1.10 PITCH 1.10 PITCH Ø0.128 0.25 0.25 6.00 21 PL Ø0.128 21 PL 0.063 REF 0.063 REF **D4114-1 DOOR DOUBLER, LH D4114-2 DOOR DOUBLER, RH** NOTES:
1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA DESIGN DART AEROSPACE LTD 2) FINISH: NONE.
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D4114-X & B/N PER QSI 044 6.1 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4114 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE 7) WEIGHT -1 & -2: 0.35 lbs DOOR DOUBLER DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE COCAMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONCEIN
NOT TO BE USED FOR ANY PLIPPOSE ON COMPANION TO TO ANY OTHER RICES. DATE 10.07.20 3

97620